



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

20NR-54

Job Sheet 192960



Part No: 20NR-54

Job Qty: 20 pcs

Part Name: Lock Bearing Pin

Need x2 - order 14758



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/4/19

Job Tracking No:

Due Date: 4/15

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG 20NR-54 REV 3A IPP Rev. A 19.04.04 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	SL-154 - 1	20 pcs	5/9/19	5/9/19	0.00	4.00	SL-154 - 1	JB 19-04-06
110	QC 2	20 pcs	5/9/19	5/9/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 56	
							QC 2 - 57	
							QC 2 - 62	JB 19-04-06
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	
							QC 2 - 65	
							QC 2 - 5	
120	QC 8	20 pcs	5/9/19	5/9/19	0.00	0.00	QC 8 - 12	
							QC 8 - 14	
							QC 8 - 17	
							QC 8 - 20	
							QC 8 - 25	
							QC 8 - 3	
							QC 8 - 32	
							QC 8 - 33	
							QC 8 - 35	
							QC 8 - 39	
							QC 8 - 4	

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Container No: S170161



Part: 20NR-54

Job No: 192960

Serial No/Batch: S170161

Revision: 3A

Inspector:

Exp Date:

Plexus name

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				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	5.19-04-06
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
130	Outsource - 15 - Nickel Plate 20 pcs	5/9/19		GRO002-VC	04/09/2019
140	Packaging 2-1 - Receive - B4B 20 pcs	5/9/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	APR 15 2019
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
150	QC 6 20 pcs	5/9/19	0.00 0.00	QC 6 - 9	APR 16 2019
				QC 6 - 68	
				QC 6 - 61	
160	Packaging 3-1 - Stock - B4B 20 pcs	5/9/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
170	QC 21 - SA 20 pcs	5/9/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

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DAS
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Part Op 100 - 1-Machine as per folio FC 742 FOLIO REV: AA DWG REV: 3A 2-Deburr
Descriptions: 130 - -Issue P/O: 043152 -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004- .0006 -Bake after
plating -Material type; 4140 -Certificate of Conformity is required
140 - Certificate of Conformity is required

Job BOM

Job BOM records could not be found.

MT-4140 QT- R 0.325 .13/each.

5154127

Job Allocations

Job Allocations could not be found.

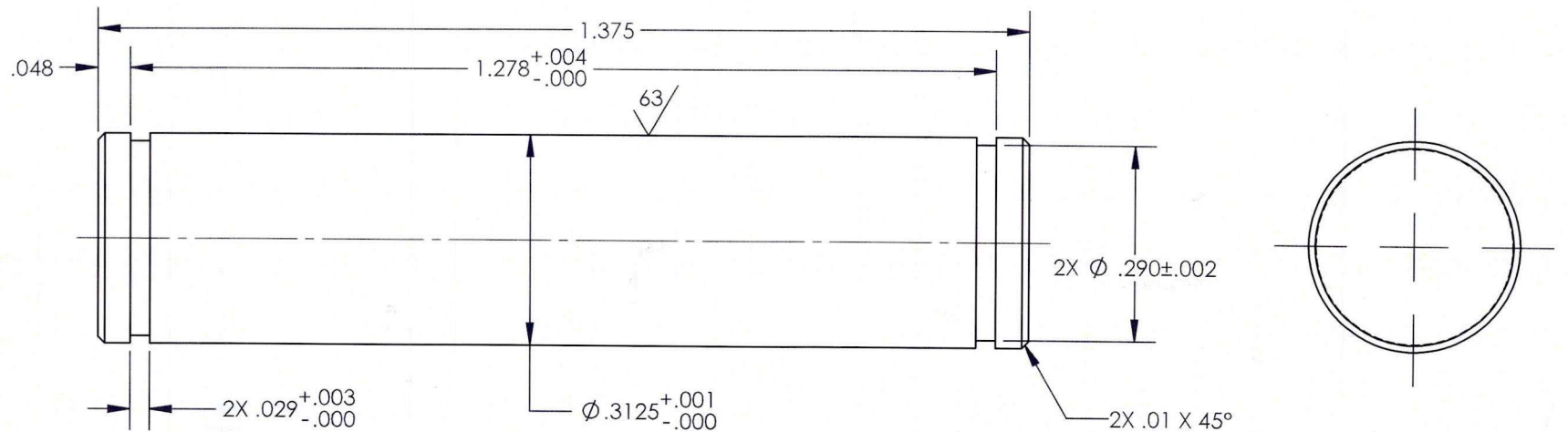
Part Specifications

Specifications could not be found.

Plex 4/4/19 3:52 PM Dart.Renwick.Jennifer

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		AS DRAWN BY CANAM	7/18/2013	CFS	
3		CH'D FINISH WAS BLACK OXIDE IS NICKEL PLATE AND BAKE PER R.W.	9/24/2013	CFS	RW
3A	14-0102	ADDED BAG & LABEL NOTE.	7/29/2014	DJN	RW



NOTES:

1. NICKEL PLATE .0004 - .0006, BAKE AFTER PLATING.
2. BAG & LABEL WITH BATCH NUMBER.

USED ON
20NR
8NR

DART AEROSPACE	
TITLE LOCK BEARING PIN	
DWG NO. 20NR-54	REV 3A
MAT'L 4140	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005	HEAT TREAT RC 28-30
.XX ± .01	FINISH SEE NOTE 1
.X ± .1	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
SCALE 4:1	DATE 5/29/1997
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			20NR-54	1	LOCK BEARING PIN	4140	Ø3/8 X 1-1/2



Dart Aerospace Ltd.
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K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO043152



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO043152

PO Date: 4/9/19

Due Date: 4/15/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	192960	20NR-54	Lock Bearing Pin -Issue P/O; -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004-.0006 -Bake after plating -Material type; 4140 -Certificate of Conformity is required	Firmed - X20	-	4/15/19	20 pcs	0 pcs	20 pcs	\$6.666/pcs	\$133.32

APR 15 2019

DP

Line Item Note *** NEED BACK APRIL 15,2019 ***

2	191272	20NR-72	Light Release Pivot Bushing (Outside Processing - Nickel Plate)-Issue P/O to GROUPE ALTECH: P/O -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004-.0006 -Bake after plating -Material type; 4140 -Certificate of Conformity is required	Firmed - X6	-	4/15/19	6 pcs	0 pcs	6 pcs	\$6.666/pcs	\$40.00
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APR 15 2019

DP

Line Item Note *** NEED BACK APRIL 15,2019 ***



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Hawkesbury, ON
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PURCHASE ORDER

PO043152



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	190624	20NR-93	Stop Block -Issue P/O; -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004-.0006 -Bake after plating -Material type; 4140 -Certificate of Conformity is required	Firmed	-	4/15/19	10 pcs	0 pcs	10 pcs	\$6.666/pcs	\$66.66

X10

APR 15 2019

DP

Line Item Note *** NEED BACK APRIL 15,2019 ***

Grand Total: \$239.98

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 4/10/19 8:47 AM dart.Lussier.Patrick



Certificat de Conformité / Certificate of Compliance

(018362-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupaltech.com

Bon de Livraison / Packing Slip

018362 - 1

Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition Ship date		Crée Par Generated By		Transport / No de Compte Courtier / Acc. No.		Bon de commande Client Customer Purchase Order No.				
11-Apr-2019		SVETLANA DORZHIYEVA				043152				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	Quantités / Quantities À venir / Back Order		
1	20NR-54 Rev.	20NR-54 01 -E-NIC STEEL 200 [E-NICKEL STEEL 200] QQ-N-290 CLASS 2 GRADE E OR F NICKEL PLATE 0.0004 TO 0.0006 BAKE AFTER PLATING	E-NICKEL-200 CH	20	20	0	0	0	0	
2	20NR-72 Rev.	20NR-72 01 -E-NIC STEEL 200 [E-NICKEL STEEL 200] QQ-N-290 CLASS 2 GRADE E OR F 0.0004-0.0006 THICK BAKE AFTER PLATING	E-NICKEL STEEL CH	6	6	0	0	0	0	
3	20NR-93 Rev.	20NR-93 01 -E-NIC STEEL 200 [E-NICKEL STEEL 200] QQ-N-290 CLASS 2 GRADE E OR F NICKEL PLATE 0.0004 TO 0.0006 BAKE AFTER PLATING	E-NICKEL-200 CH	10	10	0	0	0	0	

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.